

Date: Thursday, 06/11/2008 3:45:52 PM  
 User: / Julie Dawson

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : MAIN BODY
Job Number : 43258	
Estimate Number : 10446	
P.O. Number :	Part Number : D33721
This Issue : 06/11/2008 S.O. No. :	Drawing Number : D3372 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 41526	Material :
Written By :	Due Date : 14/11/2008 Qty: 7 Um: Each
Checked & Approved By : <u>J.D. 08.11.06</u>	
Comment : Est. A 05.01.18 New issue KJ/JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6B3000X01500	6061-T6 Bar 3.00 x 1.50
-----	--------------------	-------------------------



Comment: Qty.: 0.9254 f(s)/Unit Total : 6.4776 f(s)  
 Material: 6061-T6 Bar (QQ-A-225/8 or QQ-A-200/8)  
 (M6061T6B3.000x01.500)  
 Identify for D3372-1  
 Batch: M109058

+2 parts same batch. SF 08/11/11  
mk 08/11/09 → (9)

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW  
 Cut blank: 1.500" x 3.000" x 4.450" long

mk 08/11/09 (9)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1  
 Machine D3372-1 as per Folio FA496 and Dwg D3372  
 Identify as D3372-1  
 Deburr

SF 08/11/11 (9)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SF 08/11/11 (9)

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK


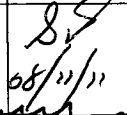
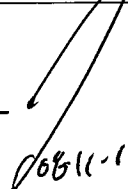
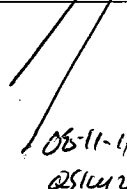
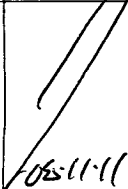
J.L 08/11/11

Pro

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3372-1 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>4325B</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-11-11	3.0	3 part the Diameter of .377 +.005 was too big .386" -.000		Acceptable as is. <del>Correct the program</del>				
		RC. Program error and Setup error on other ships. Too fast.						

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 43258
<b>Description:</b> Main Body		<b>Part Number:</b> D3372-1
<b>Inspection Dwg:</b> D3372	<b>Rev:</b> B	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.377	+0.005/-0.000	.379	✓			
0.313	+/-0.010	.313	✓			
0.750	+/-0.010	.752	✓			
1.375	+/-0.010	1.379	✓			
2.938	+/-0.010	2.937	✓			
2.200	+/-0.010	2.201	✓			
4.31	+/-0.030	4.313	✓			
1.50	+/-0.030	1.491	✓			
Ø1.300	+0.005/-0.000	1.300	✓			
1.400	+/-0.010	1.398	✓			
0.635	+0.010/-0.000	.635	✓			
0.750	+/-0.010	.750	✓			
0.200	+/-0.010	.200	✓			
Ø0.750	+0.010/-0.000	.750	✓			

<b>Measured by:</b> SP	<b>Audited by:</b> JL	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 08/11/11	<b>Date:</b> 08/11/11	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue	KJ/JLM	
B	08.09.09	Dimensions revised	KJ/DD	

Date: Thursday, 06/11/2008 3:45:52 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MAIN BODY

Job Number: 43258

Part Number: D33721

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



9X

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-L 08/11/12

7.0

POWDER COATING

POWDER COATING



M18052



9X

Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

Mask all holes

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:30  
320 OF  
2:00

M-L 08/11/14

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



8/11/14



SD

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



9X

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 7913

8/11/14

SD

10.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/14

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



M-L 08-11-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

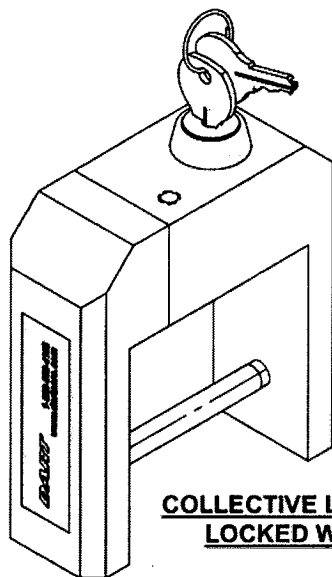
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

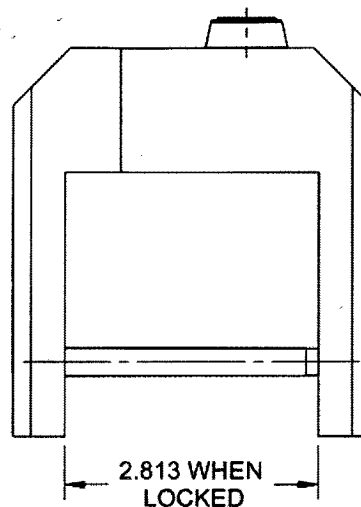
**NOTE:** Date & initial all entries



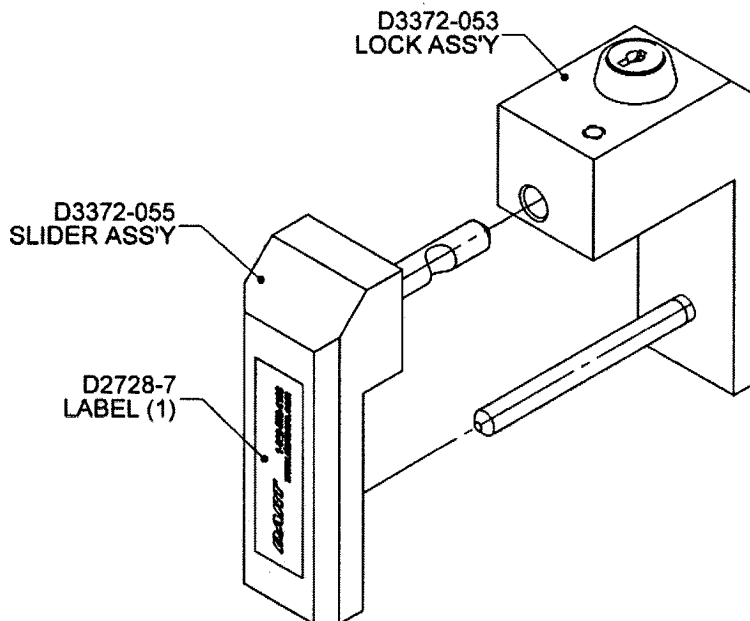
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DATE <b>05.02.23</b>		TITLE <b>COLLECTIVE LOCK</b>	SCALE 1:2
A	05.01.10	NEW ISSUE	
B	05.02.23	REDESIGN FOR STANDARD 1/4 TURN LOCK, D3369-5 SUPERCEDES D3372-11 (OBSOLETE)	



**COLLECTIVE LOCK SHOWN  
LOCKED WITH KEYS**



2.813 WHEN  
LOCKED



**D3372-051 AS350 COLLECTIVE LOCK ASS'Y**

**NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES

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*[Signature]*  
05/04/28

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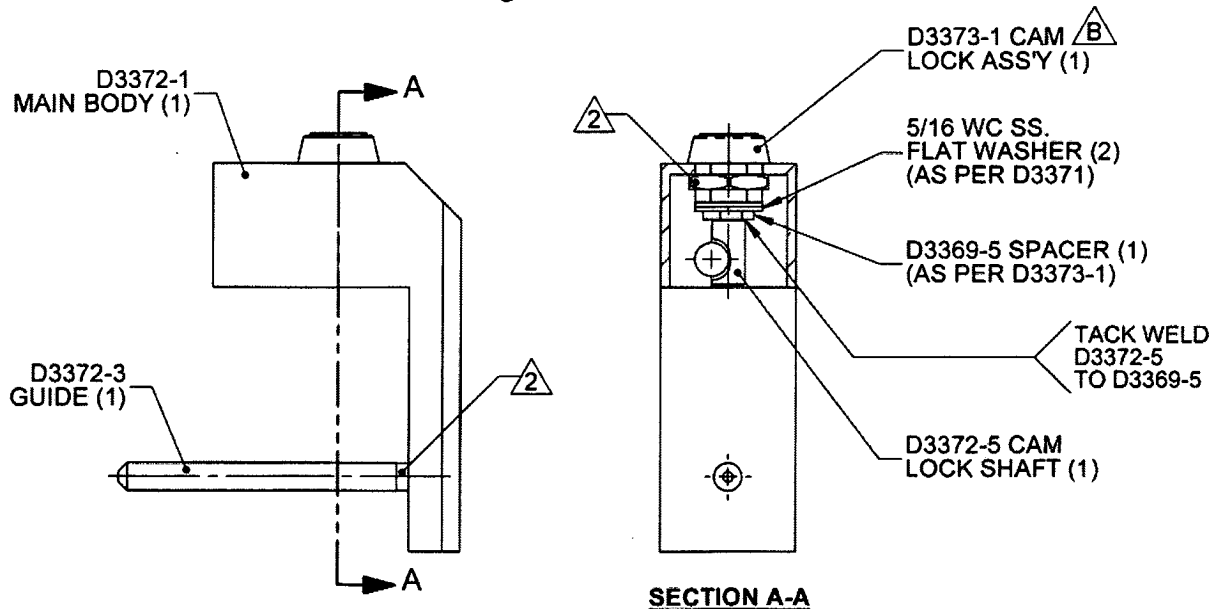
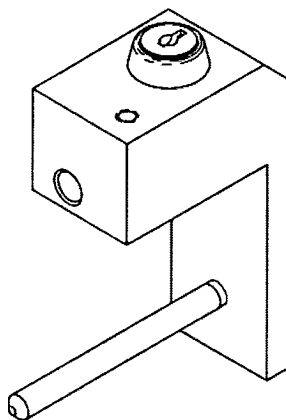
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DATE <b>05.02.23</b>		TITLE <b>COLLECTIVE LOCK</b>	SCALE 1:2

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**D3372-053 LOCK ASS'Y**

**NOTES:**

- 1) WELD PER DART QSI 004
- 2) APPLY THREADLOCKER LOCTITE 262 ON THREADS

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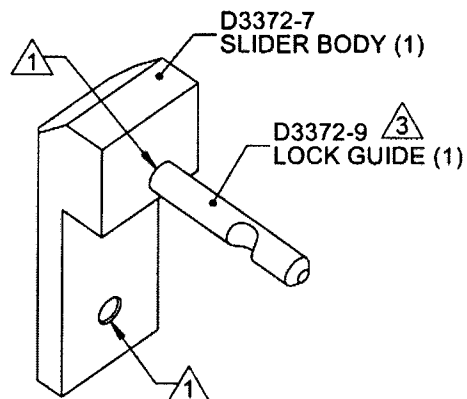
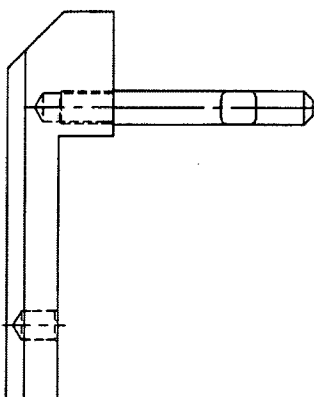
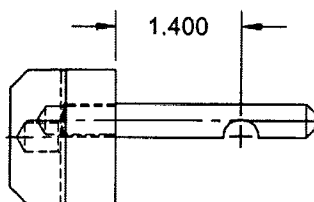
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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2

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05/04/28



### D3372-055 SLIDER ASS'Y

#### NOTES:

- 1) COVER INSIDE HOLES AND D3372-9 PRIOR PAINTING
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) APPLY THREADLOCKER LOCTITE 262 ON D3372-9 THREADS PRIOR ASSEMBLY
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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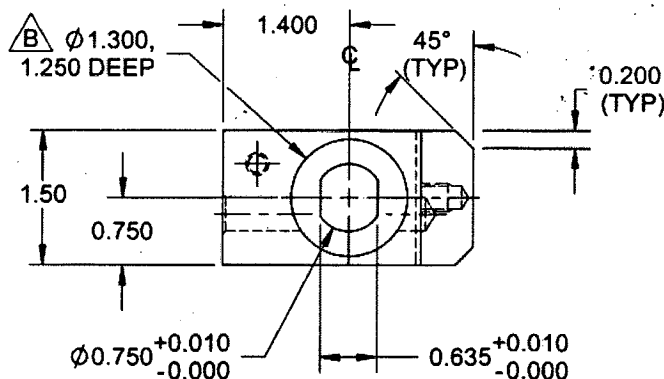
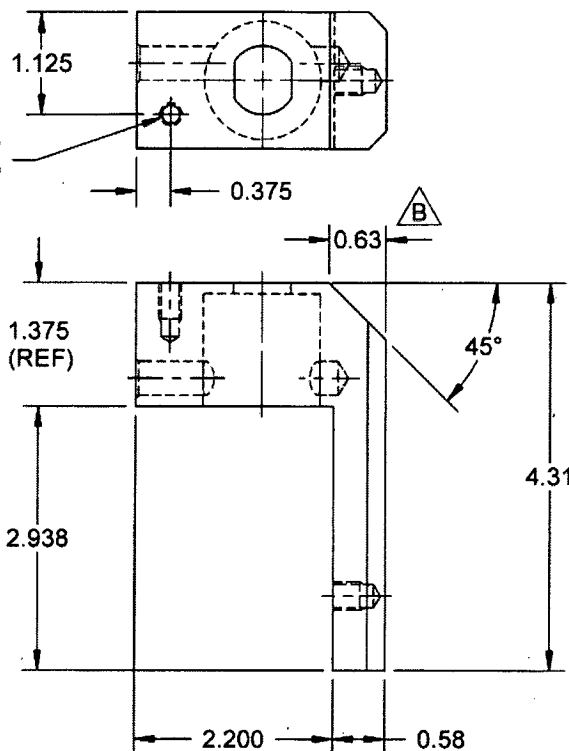
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DATE <b>05.02.23</b>		TITLE <b>COLLECTIVE LOCK</b>	SCALE 1:2

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2 DRILL  $\phi 0.201$  x 0.600 DEEP  
TAP 1/4-20 UNC x 0.400 DEEP

2 DRILL  $\phi 0.377$ ,  
2.363 DEEP.  
CHAMFER 0.031 x 45°

2 DRILL "I" DRILL  
x 0.525 DEEP  
THREAD 5/16-24 UNF  
x 0.300 DEEP



### D3372-1 MAIN BODY

#### NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)  
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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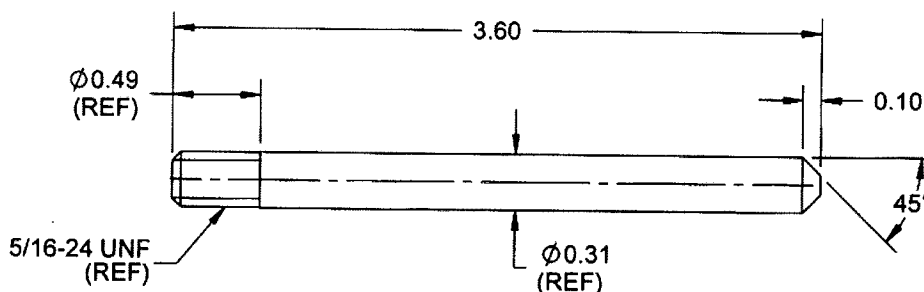
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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:1

## SPECIFICATION CONTROL DRAWING

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*[Signature]*  
05/04/23



### D3372-3 GUIDE

#### NOTES:

- 1) MATERIAL: AN5-42A BOLT MODIFIED AS SHOWN.
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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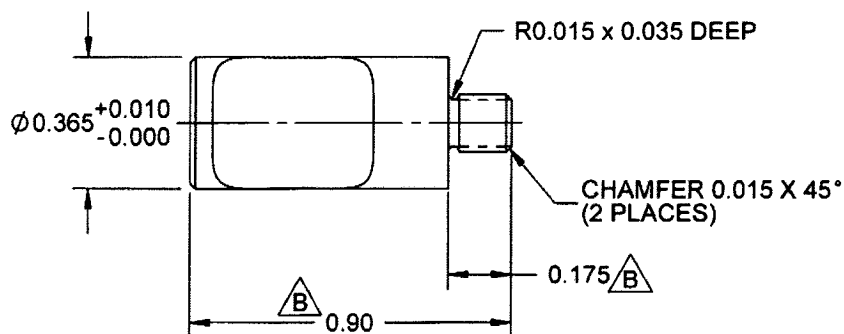
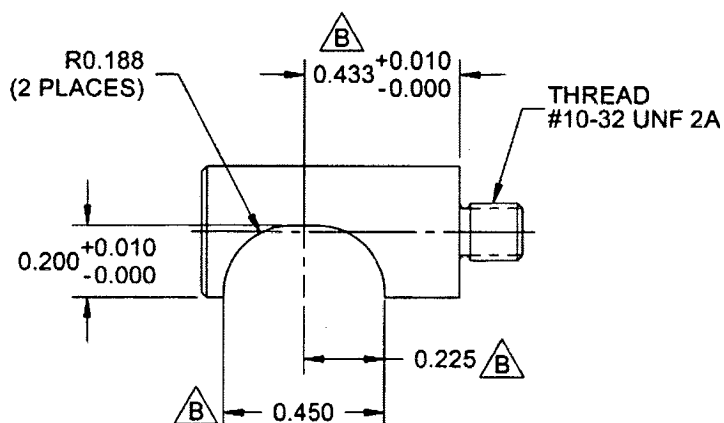
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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 2:1

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### D3372-5 CAM LOCK SHAFT

#### NOTES:

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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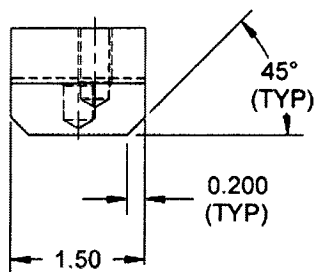
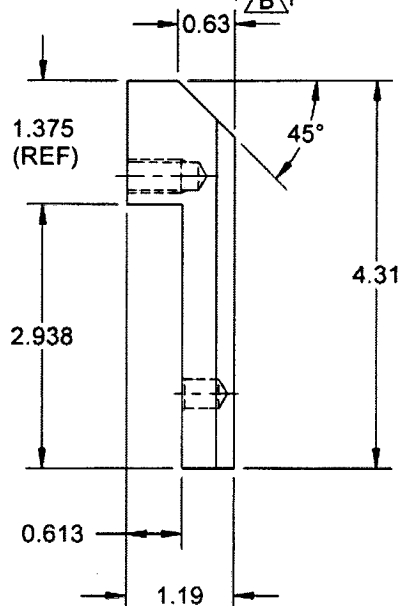
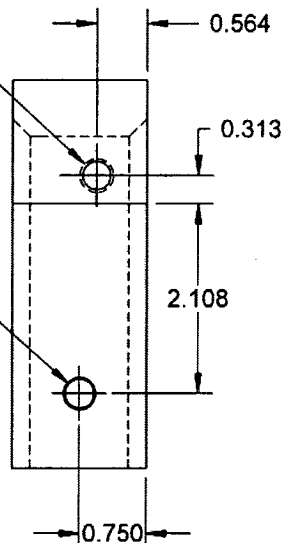
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DATE <b>05.02.23</b>		TITLE <b>COLLECTIVE LOCK</b>	SCALE 1:2

DRILL  $\phi 0.332$   
("Q" DRILL) x 0.881 DEEP,  
THREAD 3/8-24 UNF x 0.600 DEEP

DRILL  $\phi 0.323$   
("P" DRILL) x 0.500 DEEP  
CHAMFER 0.030 x 30°



### D3372-7 SLIDER BODY

#### NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)  
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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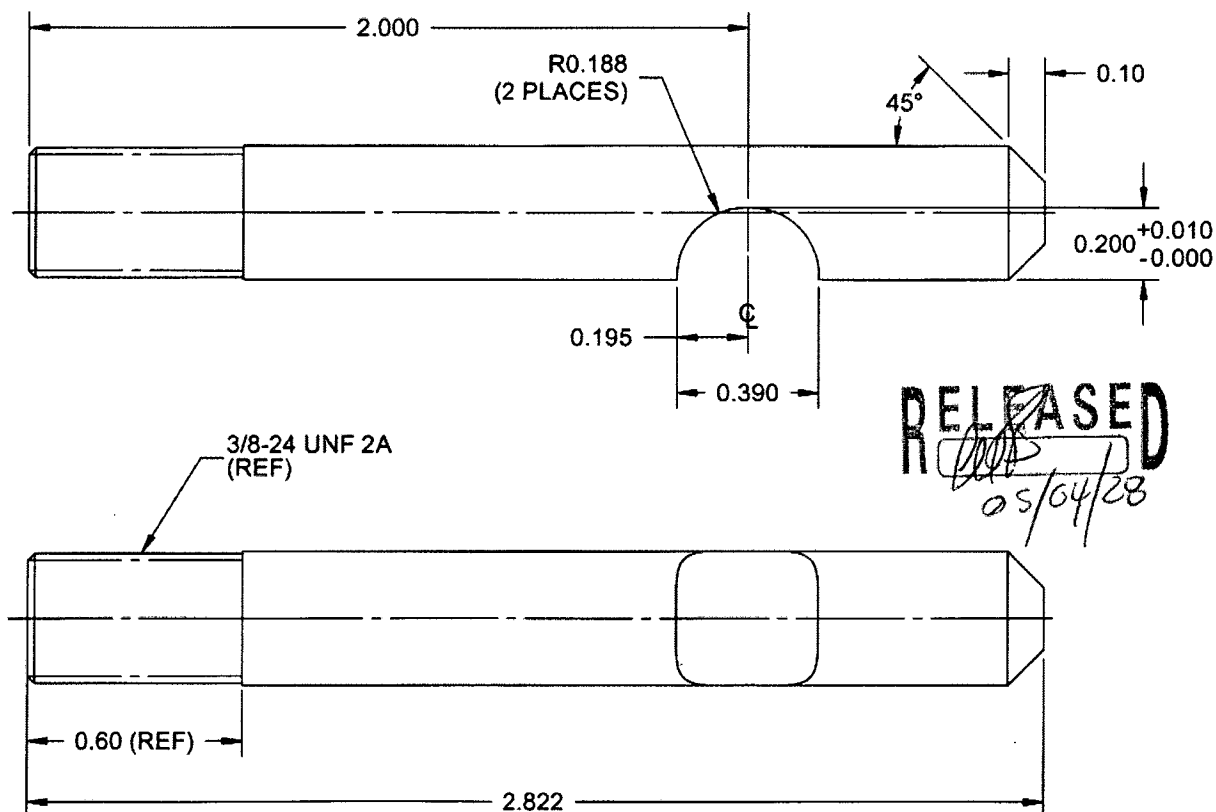
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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 2:1

## SPECIFICATION CONTROL DRAWING



### D3372-9 LOCK GUIDE

#### NOTES:

- 1) MATERIAL: AN6-36A BOLT, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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